












Date: Tuesday, 15/07/2008 4:19:54 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUIDE
Job Number	: 40531		
Estimate Number	: 12807		
P.O. Number	:	Part Number	: D35713
This Issue	: 15/07/2008 S.O. No. :	Drawing Number	: D3571 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 39374	Material	:
Written By	:	Due Date	: 05/08/2008 Qty: ²⁰ / ₁₂ Um: Each
Checked & Approved By	: <u>JLD 08.7.16</u>		
Comment	: Est Rev:A New Issue 07-02-01 JLM Est Rev:B Remove manual Machinig 08-05-26 JLM Verified By:EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"	
			
Comment: Qty.: 0.2531 f(s)/Unit Total: 3.0366 f(s) 6061-T6 Bar .75" X 1.5" Batch: <u>M108118</u> <u>JL 08/07/18</u> (20)			
2.0	BAND SAW	BAND SAW	
			
Comment: BAND SAW Cut blank 2.90 " long <u>JL 08/07/18</u> (20)			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA681 Rev: <u>AA</u> & Dwg D3571 Rev: <u>A</u> 2-Deburr per dwg D3571 <u>JL 08/07/28</u> (20)			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>JL 08/07/28</u> (20)			
5.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>JL 08/07/28</u> (20)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3571-3 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 28/08/24
 QA: N/C Closed: _____ Date: _____

NCR: 40531		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/23	* SD	Docking machine sh. 0.260" slot was maching at 0.264" R.C. see Program mod.	PH QSI 042 03.07.24	Critical dimension is 0.188 Part is still within 0.188 ± 0.010 Therefore, acceptable, see attached	PH QSI 042 03.07.24	<u>08/07/24</u>	PH QSI 042 03.07.24	<u>08/07/23</u>

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 40531

Part Number: D35713

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(20x)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 08/07/30

7.0

POWDER COATING

POWDER COATING



M 106442



(20x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00
320
8:30

M-L 08/7/31

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(20x)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/07/31

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(20x)

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: *24P*

8/7/31 *SP*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/01 *KA*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08-08-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 40531
Description: Guide		Part Number: D3571-3
Inspection Dwg: D3571	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

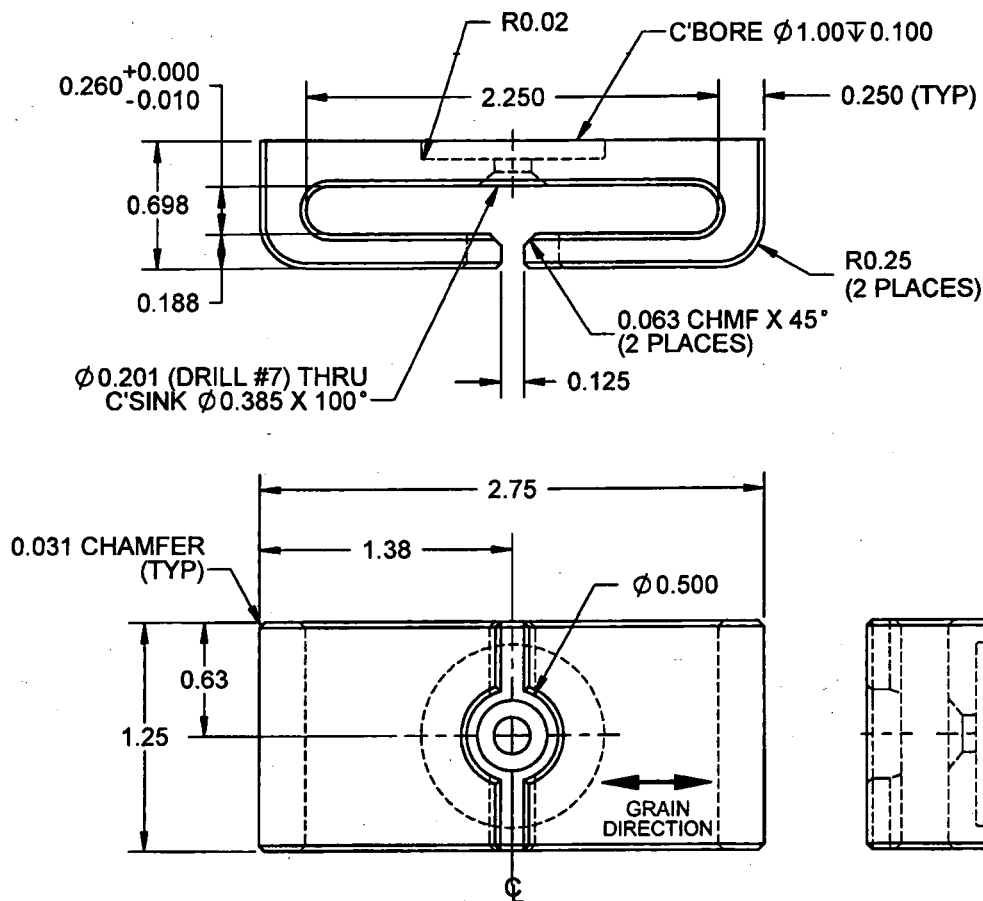
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	.699	✓			
2.75	+/-0.030	2.750	✓			
1.38	+/-0.030	1.377	✓			
1.25	+/-0.030	1.250	✓			
0.63	+/-0.010	.626	✓			
0.031 chamfer	+/-0.010	.032	✓			
Ø0.500	+0.006/-0.001	.501	✓			
Ø0.201	+0.005/-0.001	.202				
R0.25	+/-0.030	1.25	✓			
0.260	+0.000/-0.010	.256	✓			
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	.386 x 100°	✓			
0.125	+/-0.010	.127	✓			
2.250	+/-0.010	2.245	✓			
0.250	+/-0.010	.250	✓			
0.188	+/-0.010	.185	✓			
0.063 chamfer	+/-0.010	.065	✓			

Measured by: JL	Audited by: SJS	Prototype Approval:	N/A
Date: 08/07/23	Date: 08/07/23	Date:	N/A

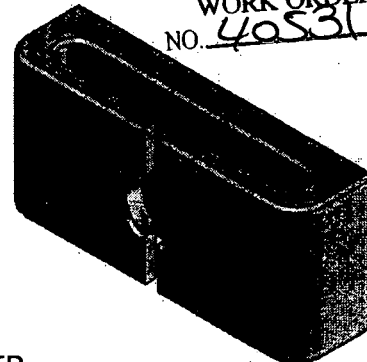
Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 1 OF 2
DATE 07.01.29	TITLE GUIDE SCALE 1:1		
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

RELEASED07.04.12 *[Signature]***D3571-1 GUIDE**

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *40531*

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

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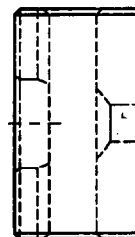
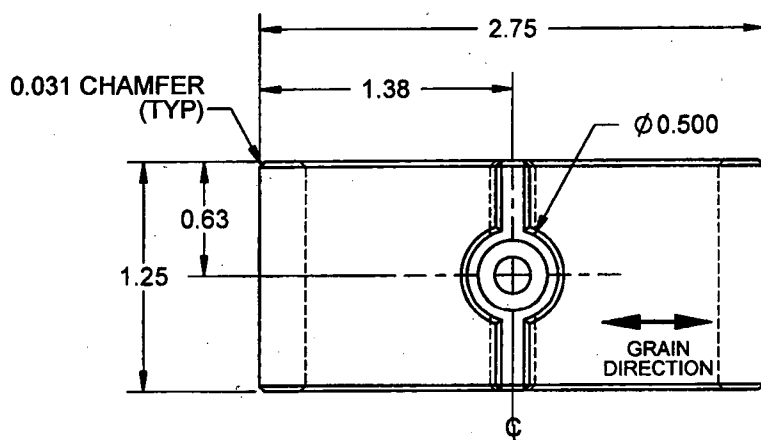
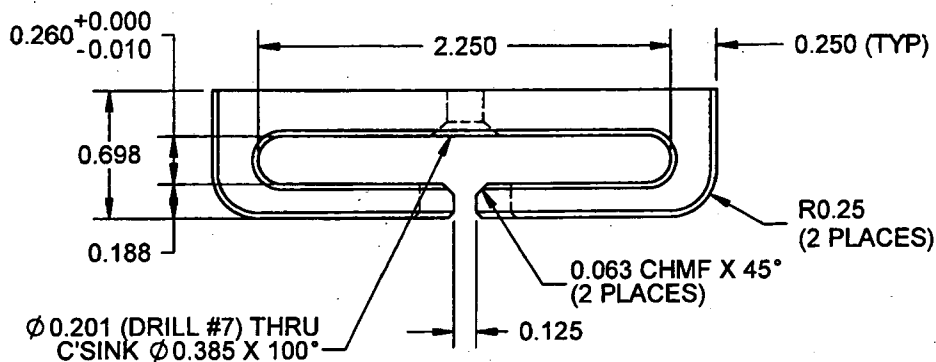
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DATE 07.01.29		TITLE GUIDE	SCALE 1:1

RELEASED

07.04.12

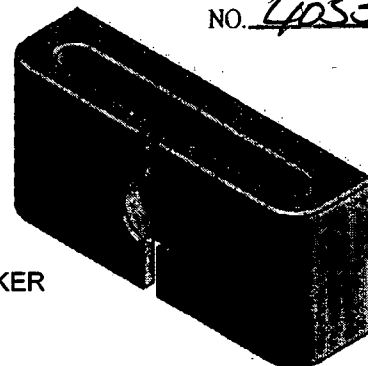


D3571-3 GUIDE

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NO. 4053

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ



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Peter Hum

From: David Shepherd [dshepherd@dartaero.com]
Sent: Thursday, July 24, 2008 2:05 AM
To: 'Peter Hum'
Subject: RE: D3571-3 Guide out of tolerance

Peter

This part can be heavily loaded in service. As long as the 0.188 dimension is within tolerance, I think we can accept this part at 0.264.

David

From: Peter Hum [mailto:phum@dartaero.com]
Sent: Wednesday, July 23, 2008 12:52 PM
To: 'David Shepherd'
Subject: D3571-3 Guide out of tolerance

David,

Machining the 1st off for a D3571-3 Guard for the D412-702 Shoulder Harness. The Dimension 0.260 (+0.000 / -0.010) is at 0.264. I believe this part just guide the shoulder harness to the correct location and not loaded. See attached

Is this deviation acceptable?

Peter

No virus found in this incoming message.

Checked by AVG.

Version: 7.5.524 / Virus Database: 270.5.5/1569 - Release Date: 7/23/2008 1:31 PM

No virus found in this outgoing message.

Checked by AVG.

Version: 7.5.524 / Virus Database: 270.5.5/1569 - Release Date: 7/23/2008 1:31 PM